

Work Order ID 161593

Friday, May 26, 2017 7:53:13 AM

161593

Page 1

BWE

Item ID: D3407-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tow Ring
 Start Date: 6/2/2017 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 6/14/2017 Req'd Qty: 24.00 ***24*** Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: MAY 26 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								
100	Large Fab	0.00							
100									
Large Fab	Memo	4.08							
Large Fab	Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004A/R TIG174 ROD Batch: <u>M102576</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.48							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.48							
Quality Control									

(24)

DYC
17/08/14

(24)

17-08-15

DAS
9
9-89

(24)

17-08-15

DAS
9
9-89

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Setup Start *NS1*

Stop *NS2*

Customer:

Run Start *NP1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

135

0.00

135

SprayPaint

Spray Painting

Memo

PRIME B

0.00

DAS
13
8-88

DELFLEET BLUE B

DELFLEET CLEAR B

145

QC14- Inspect Spray Paint

0.00

145

QC

Quality Control

Memo

0.00

150

Identify as per dwg & Stock Location: 51 530

0.00

150

Packaging

Packaging

Memo

2.40

Received 24x SpA8-24.

DA
38
AUG 28 441

24 AUG 28 2017 DAS 6 8-89

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Item ID: D3407-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Ring
Start Date: 6/2/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 6/14/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.24							
Quality Control									

DAS
21
9-89

AUG 28 2017

Picklist Print

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Work Order ID: 161593

161593

Parent Item: D3407-043

D3407-043

Parent Item Name: Tow Ring

Start Date: 6/2/2017

Required Date: 6/14/2017

Start Qty: 24.00

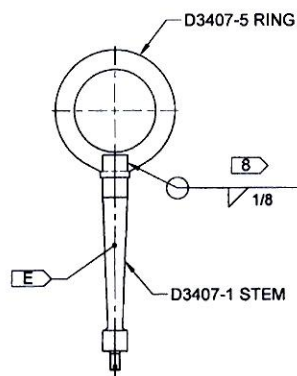
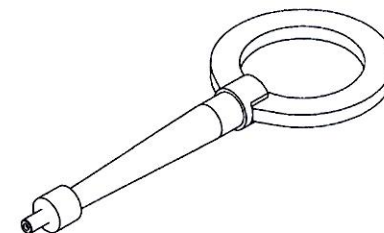
Required Qty: 24.00

Comments: IPP Rev:A05.10.14New issueKJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

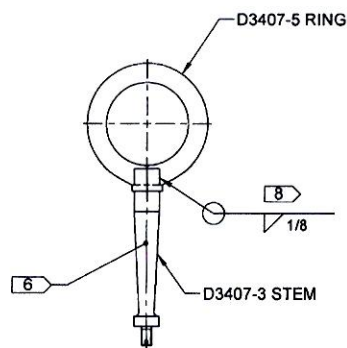
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-3		Manufactured	No			100	Each	0.0000	1	24			
ok *D3407-3*						B164239	24X		**	DYC	17/08/14		
Stem													
D3407-5		Manufactured	No			100	Each	0.0000	1	24			
D3407-5									**	DYC	17/08/14		
Ring													
						B161752	8K						
						B161594	16X						

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

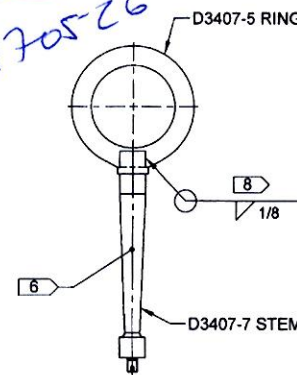
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161593 MJS
170526



D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

RELEASED

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37518**

Purchase Order Date 8/22/2017

PO Print Date 8/23/2017

Page Number 1 of 5

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

819 242 5633

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	161172	D206-667-207BL Aft crosstube	8/24/2017 Yes 8/24/2017		1.00	\$225.00	\$225.00
	Prime and Paint Deflect Blue						
						Line Total:	\$225.00
2	161176	D206-667-207BL Aft Crosstube	8/24/2017 Yes 8/24/2017		1.00	\$225.00	\$225.00
	Prime and Paint Deflect Blue						
						Line Total:	\$225.00
	161593	D3407-043 Tow Ring	8/24/2017 No 8/24/2017		24.00	\$15.00	\$360.00
	Prime and Paint Deflect Blue						

Note:

8/23/2017

DAE
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SPR-8-24